


Date: Monday, 3/19/2007 8:12:52 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 31254		
Estimate Number	: 10299		
P.O. Number	: N/A	Part Number	: D25775
This Issue	: 3/19/2007 S.O. No. : N/A	Drawing Number	: D2577 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 30879	Material	: N/A
Written By	:	Due Date	: 4/4/2007 Qty: 50 Um: Each
Checked & Approved By	: <u>HJ 07.03.19</u>		
Comment	: Est: F 02.09.24 Re-format KJ/RF		
	: Est Rev:D Now on Waterjet 06-06-14 JLM		

Additional Product



Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0

M1010S16GA

1010/1025/A21/6aA SHEET

Comment: Qty.: 1.0301 sf(s)/Unit Total: 51.5025 sf(s)
1010/1025 16GA SHEET
(m1010s16ga)
Batch: ~~M103788~~ M103434 (12)
M103840 (23) M103788 (14) 500 07/04/08

2.0	WATER JET	FLOW WATER JET
		

Comment: FLOW WATER JET
1-Cut as per Dwg D2577
Dwg Rev: E
Prog Rev: E

2-Deburr if necessary

Jim 07/04/09 50
JAD 03/04/08 50

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

Comment: DIMENSIONAL CHECK
Inspect dimensions per template D2577-5T1

40	QC8	SECOND CHECK	
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Comment: SECOND CHECK	En 07/04/09 x 50
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5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

Comment: SMALL & MEDIUM FAB RESOURCE 1
Debur

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Q Date: 07/04/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:12:52 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 31254

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

MF.

07-04-10.

mk

07-04-10

(50)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-04-11

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005.4.3

FR

07/04/11

(50)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MR

07/04/11

(50X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PP18

MR

07/04/11

(50X)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/11

(50)

Job Completion



U 07-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
00 09 22 11

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	
		D2577	SHEET 1 OF 5	
DATE		TITLE	SCALE	
00.09.22		WEARSHOE	1:10	
A	96.09.16	NEW ISSUE		
B	96.12.04	ADD HARDCOAT WELDS		
C	97.05.30	CHANGE HOLES TO OBROUNDS		
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3		
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176		

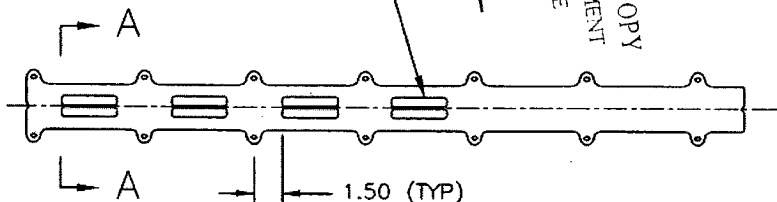
7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



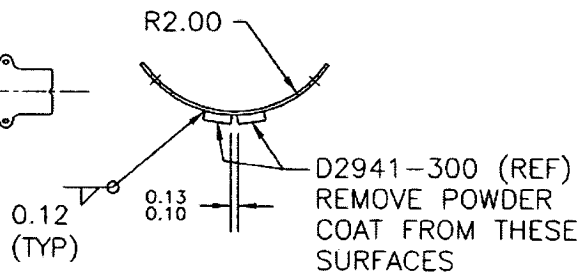
D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 31254

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



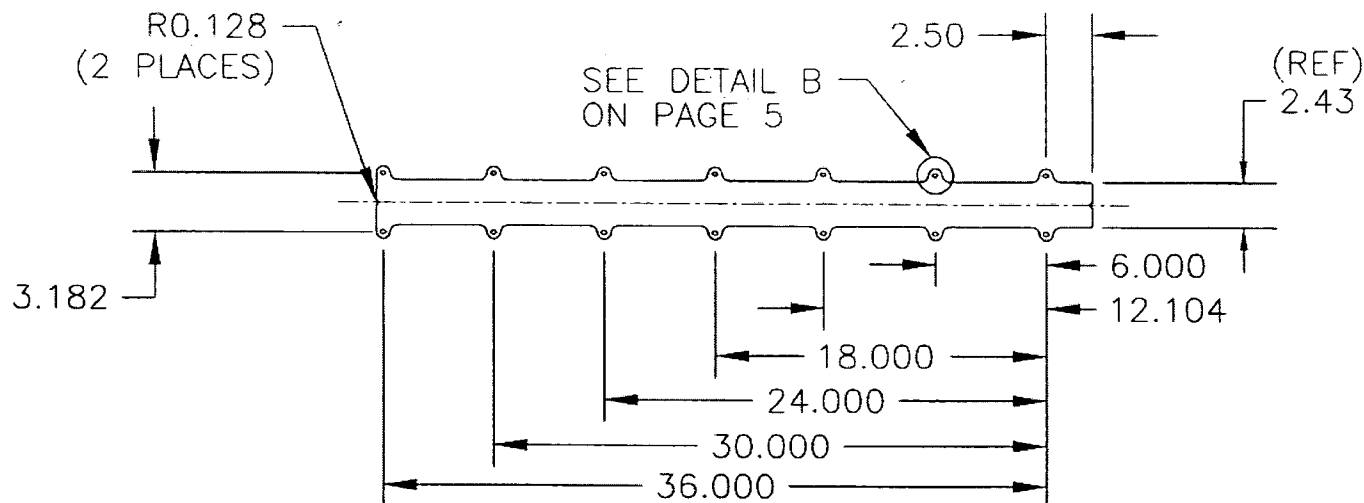
SECTION A-A
SCALE 1:5



D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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DATE 00.09.22	TITLE WEARSHOE	REV. E SHEET 2 OF 5
	SCALE 1:10	



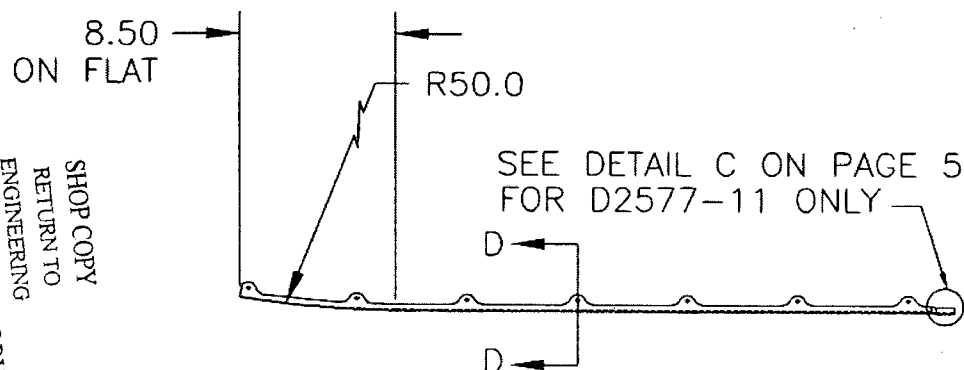
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

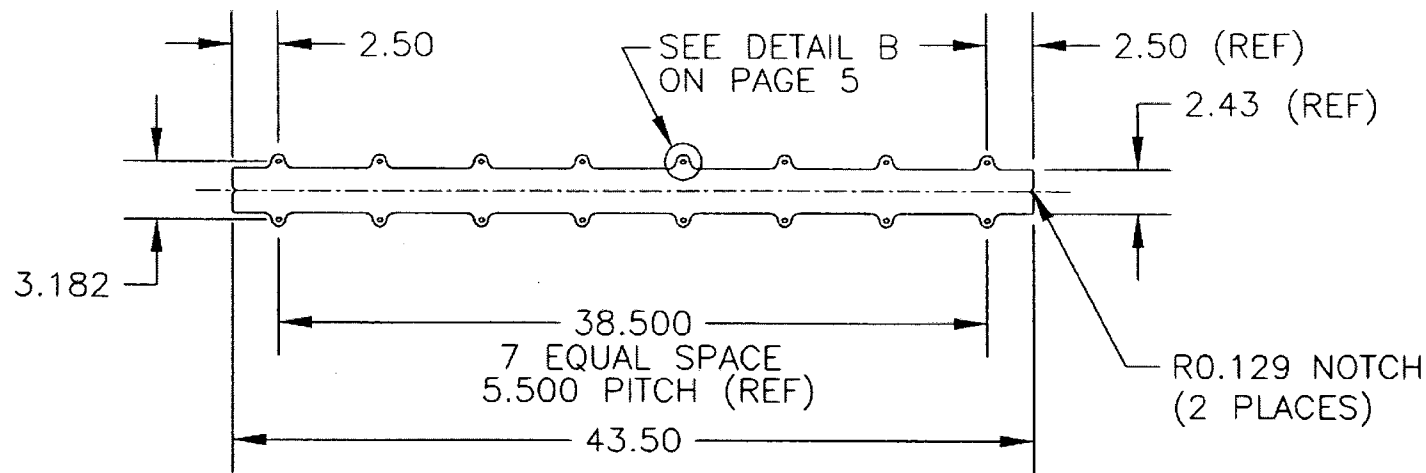
RELEASED
00.09.26



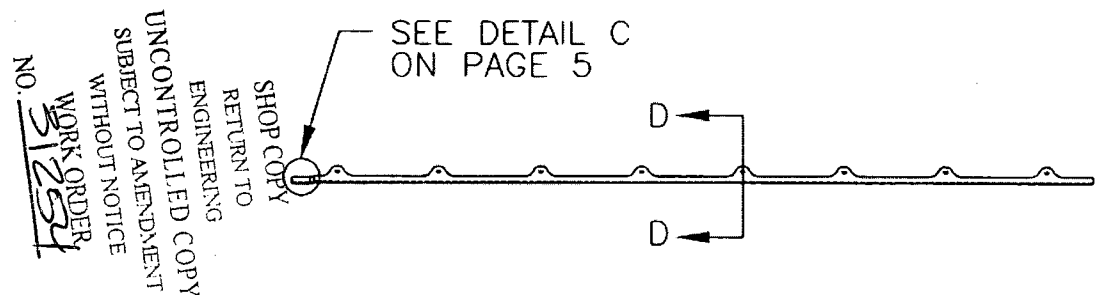
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED		
DATE	DRAWING NO.	TITLE	SHEET 3 OF 5
00.09.22	D2577	WEARSHOE	SCALE
			1:10

RELEASED
00.09.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
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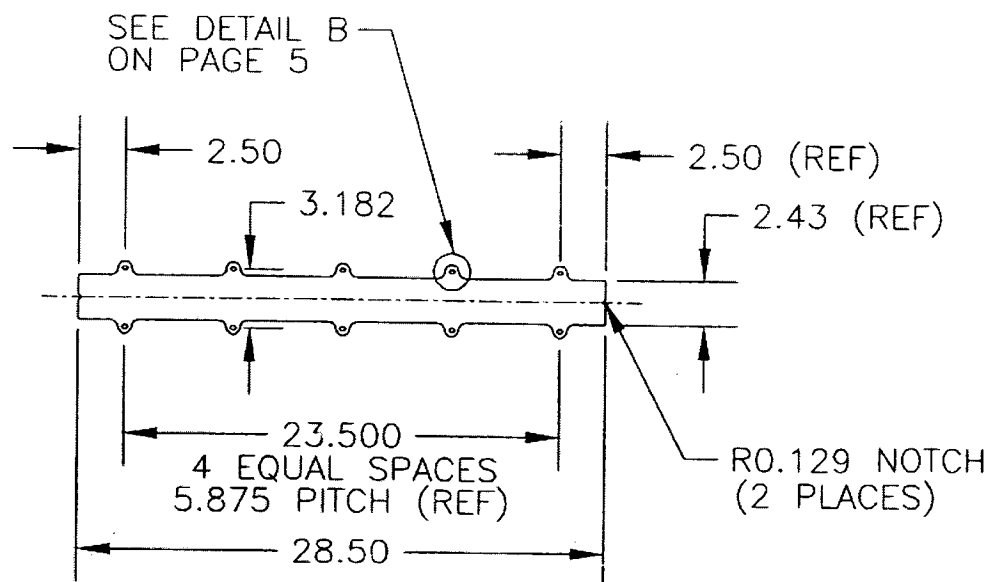
DART



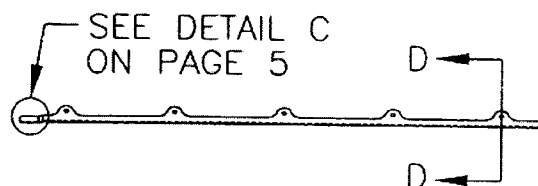
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CHECKED	APPROVED	DRAWING NO.	REV. E
DATE		D2577	SHEET 4 OF 5
00.09.22		TITLE	SCALE
		WEARSHOE	1:10

RELEASED
00.09.26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



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NO. 31251

D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

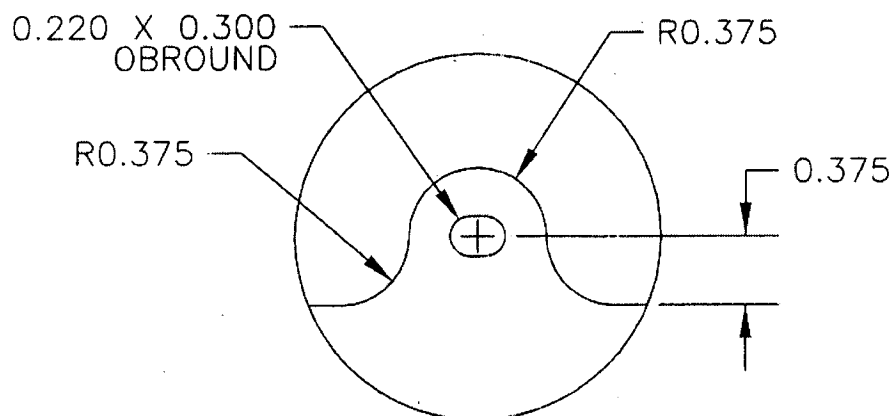
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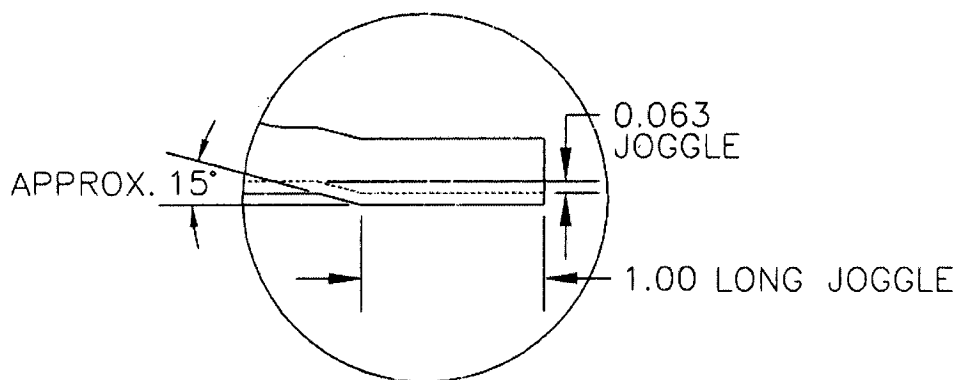
DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

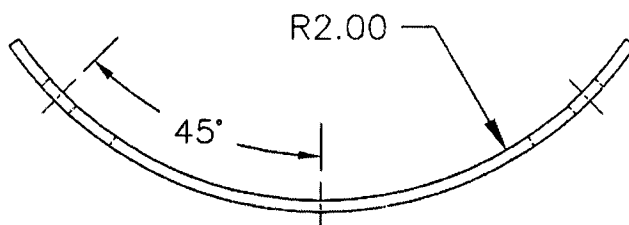
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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